

## In the Claims:

1. (Currently Amended) A method of forming a layered polishing pad comprising:
  - a) forming a first and second double-sided pressure sensitive adhesive layer on a respective bottom and top surface of a subpad with a nip roller to form a double laminated subpad, the double laminated subpad having a nip exit angle  $\gamma$  through the nip roller and wherein the first and second double-sided pressure sensitive adhesive layers can create stresses that result in curling of the double laminated subpad;
  - b) ~~forming a second double-sided adhesive layer on a top surface of the subpad, the second double-sided adhesive layer can create stresses that result in curling of the subpad~~ controlling nip exit angle  $\gamma$  to 0 degrees  $\pm$  3 degrees over a travel length to limit curling of the double laminated subpad;
  - c) providing a polishing pad layer having a lower surface; and
  - d) adhering the polishing pad layer to the double laminated subpad, the double laminated subpad including the first and second double-sided pressure sensitive adhesive layers adhered to the bottom and top surfaces, by pressing the polishing pad layer lower surface against the second double-sided pressure sensitive adhesive layer.
2. (Currently Amended) The method of claim 1, further including after act b) therein:
  - a) forming an opening that extends through the first double-sided pressure sensitive adhesive layer, the subpad and the second double-sided pressure sensitive adhesive layer;
  - b) providing the polishing pad layer with a window; and
  - c) in the adhering, aligning the window to the opening.
3. Cancelled.
4. (Currently Amended) The method of claim 1, including respectively providing material for the subpad and the first and second double-sided adhesive pressure sensitive layers in roll-good form.

5. Cancelled.

6. (Currently Amended) A method of forming a layered polishing pad, comprising:

- a) laminating a first and second double-sided pressure sensitive adhesive layer onto a respective bottom and top surface of a subpad with a nip roller to form a double laminated subpad, the double laminated subpad having a nip exit angle  $\gamma$  through the nip roller and wherein the first double-sided pressure sensitive adhesive layer can create stresses that result in curling of the subpad;
- b) controlling nip exit angle  $\gamma$  to 0 degrees  $\pm$  3 degrees over a travel length to limit curling of the double laminated subpad laminating a second double-sided adhesive layer on a top surface of the subpad, the second double-sided adhesive layer can create stresses that result in curling of the subpad;
- c) forming an opening through the first pressure sensitive adhesive layer, the subpad and the second pressure sensitive adhesive layer of the double laminated subpad; and
- d) securing a polishing pad having a window formed therein, to the double laminated subpad with the second adhesive layer, such that the window is aligned to the opening in the double laminated subpad.

7. (Original) The method of claim 6, including providing respective materials for the subpad, the first double-sided pressure sensitive adhesive layer and the second double-sided pressure sensitive adhesive layer in roll-good form.

8. Cancelled.

9. (Currently Amended) A method of forming a layered polishing pad comprising:

- a) sequentially forming respective double-sided pressure sensitive adhesive layers on opposing surfaces of a subpad with a nip roller to form a double-laminated subpad, the double laminated subpad having a nip exit angle  $\gamma$  through the nip roller and wherein the double-sided pressure sensitive adhesive layers can create stresses that result in curling of the double-laminated subpad;

- b) controlling nip exit angle  $\gamma$  to 0 degrees  $\pm$  3 degrees over a travel length to limit curling of the double laminated subpad;
- bc) forming an opening through the double-laminated subpad; and
- ed) securing a polishing pad having a window, to the double-laminated subpad by pressing a polishing pad lower surface against one of the pressure sensitive adhesive layers such that the window and opening form a through optical path that includes no pressure sensitive adhesive layer.

10. Cancelled.